

# Work Order ID 53652

November 11, 2009 3:03:10 PM

Page 1

Item ID: D2886-3

Accept

Setup Start

Revision ID: *A B*

Item Name: Cable Guard

Stop

Start Date: 11/13/09

Start Qty: 2.00

Cust Item ID:

Required Date: 11/20/09

Req'd Qty: 2.00

Customer:

Reference:



Approvals:

Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2886

Rev *A B*

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS FILE D2886-3

*B 9 11/26*

*(3)*

140

0.00



HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2886-3

*M.A 09/12/02*

*B 9 11-26*

*(3)*

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

*M.A 09/12/02*

*3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53652

November 11, 2009 3:03:10 PM



Page 2

Item ID: D2886-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cable Guard

Start Date: 11/13/09 Start Qty: 2.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC8- Inspect parts - second check

0.00

*mf 09/12/02*

*3*

*0*



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

*9/12/12 SC 34*

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/12/02*

POSITIVE RECALL

EFFECTIVE *09/11/11* AUTH *MF*

RELEASED *MF* DATE *09/12/02*

*09.12.02*

*MF 09-12-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 11, 2009 3:03:09 PM

Page 1

Work Order ID: 53652



Parent Item: D2886-3RevA



Parent Item Name: Cable Guard

Start Date: 11/13/09

Required Date: 11/20/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB1750X1000 X4800		Purchased	No			100	sf	0.0000	0.5701			
UHMW 1.75x1.00x48.00												

108762



13 9-1-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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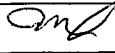
**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 53652
<b>Description:</b> GUARD	<b>Part Number:</b> D2886-3
<b>Inspection Dwg:</b> D2886 <b>Rev:</b> B	<b>Page 1 of 1</b>

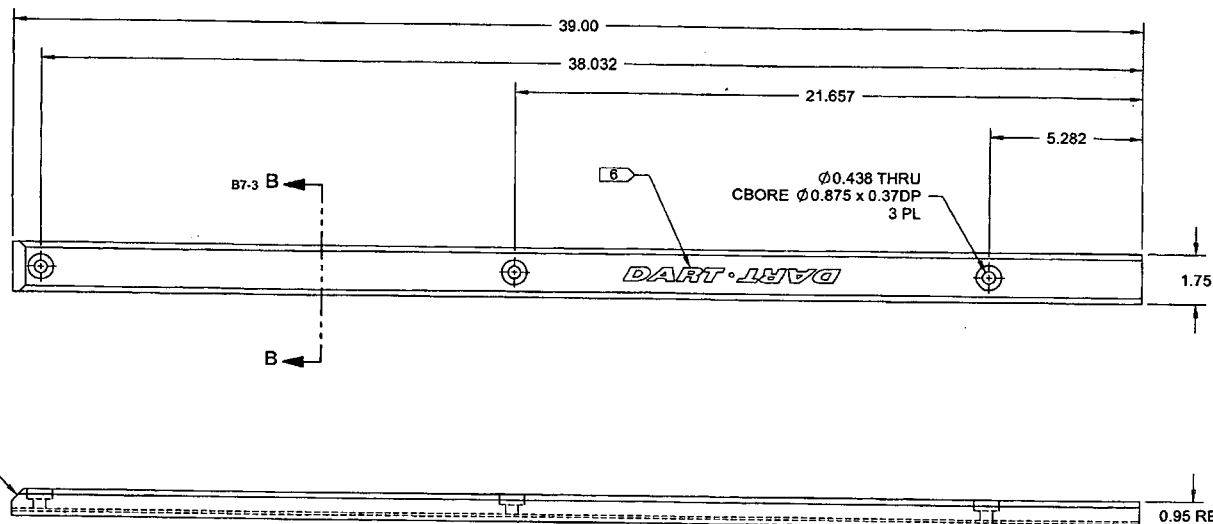
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.00	+/- .030	39.00	✓			
38.00	+/- .030	38.00	✓			
21.657	+/- .010	21.657	✓			
5.282	+/- .010	5.287	✓			
1.75	+/- .030	1.746	✓			
Ø 0.438	+ .006 / - .001	Ø 0.438	✓			
Ø 0.875 x .37 DP	+ .010 / - .001 x +/- .030	Ø 0.874 x .37 DP	✓			
0.95	+/- .030	0.945	✓			
0.44 x 45°	+/- .030	0.455 x 45°	✓			
R 2.00	+/- .030	R 2.00	✓			
0.78	+/- .030	0.780	✓			
0.70	+/- .030	0.690	✓			
0.79	+/- .030	0.795	✓			
0.950	+/- .010	0.948	✓			

<b>Measured by:</b> LA	<b>Audited by:</b> 	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/12/02	<b>Date:</b> 09/12/02	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D2886-3 GUARD**

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER DART SPEC. MUHMWB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.040 MAX
- 6) IDENTIFICATION: ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON NEAR SIDE TO MAX DEPTH OF 0.015 AND MIN TOOL RAD OF R0.250.  
ENGRAVE P/N ON FAR SIDE TO MAX DEPTH OF 0.010 AND MIN TOOL RAD OF R0.010.
- 7) WEIGHT: 2.20 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2886	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUARD	NTS
DATE	09.11.12	<small>COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2009-12-02

53652



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